Work Orde												Page 1
Item ID: Revision ID:	D3436-3			Accept				s s	Setup S	Start		
Item Name:	Left Step								:	Stop		
Start Date: Required Date:	1/6/2011 1/14/2011	Start Qty: 4.00 Req'd Qty: 4.00	i iladin badi 1881 i iladin badi iladi		Cust Item I Customer:	D:						-,- ··- ··- ·
Reference:												
Approvals:	Process Plan	1: <i>Q[</i>	Date://-/	Tooling:	Da	ite:	_	R	kun S	Start		
	QC:	/ (Date:	SPC (Y/N):		ite:			!	Stop		
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr										
D3436	Rev A	A										
100 Small Fab		Small Fab		0.00		1		B		11-	9-6	X8
Small Fab		Scribe blank D3436-3 □D	as per template DT8771 th wg Rev□Deburr	nen cut as per Dwg D343	36□Identify as							
110 QC		QC6- Inspect dimensions Memo	to drawing	0.00 Sic/	05/06			(XE))——			
Quality Control												,

120

Packaging

Packaging

Identify as per dwg & Stock Location: W/ 0.00 Memo

0.00

EL 119-6 (X8



Work Order ID 65157 Thursday, January 06, 2011 3:32:49 PM													Page
Item ID: Revision ID: Item Name:	D3436-3 Left Step				Accept				s s	etup	Start Stop	[
Start Date: Required Date: Reference:	1/6/2011 Start Qty: 4.00					Cust Item ID: Customer:					•		
Approvals:	Process Plan:QC:		Date:		Tooling: SPC (Y/N):	Date:			R		Start Stop		
Sequence ID/		Operation			Set Up/	Tool ID	Tool #	Plan A	ccept	Reje	ect	Reject	Insp.

Number Stamp

Code

Qty

Qty

Insp.

Quality Control

QC

130

Work Center ID

Description

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

Run Hours

Page 2

Picklist Print

Thursday, January 06, 2011 3:32:53 PM

Work Order ID: 65157

Parent Item:

D3436-3

Parent Item Name: Left Step



Start Date: 1/6/2011

Required Date: 1/14/2011

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP A□05.05.10□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT1.000W.049		Purchased	No			100	f	21.0313	0.5733	2.413895	5		
4130 RD Tube 1 00 X 049										A,	11-9-6		

4130 RD Tube 1.00 X .049"W

Location

MAT33

Loc Oty Loc Code 21.03125

21.03125

11.21

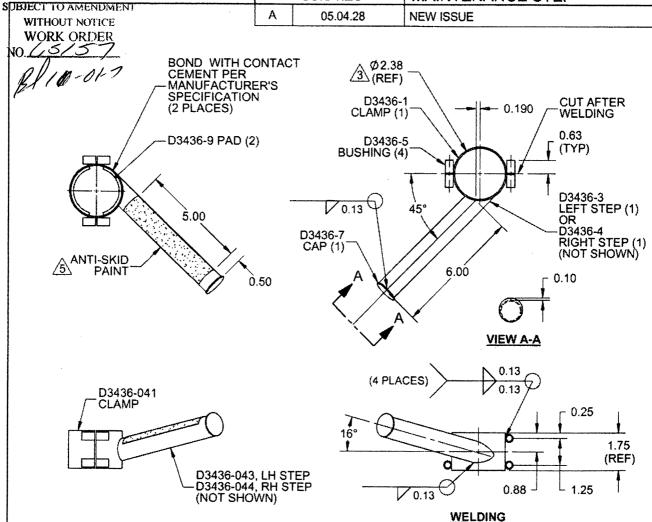
W/O:			WC	ORK ORDER CHANG	GES				-	
DATE	STEP	PR	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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···										
										: E
Part No	•	PAR #:	Fault Cate	gory:	NCR:	Yes N	lo DQ	A:	_ Date: _	
	Res	solution:	Dispositio	n:	QA: I	VC Clo	sed:		Date: _	· .
NCR:		A 32 9	WORK ORD	ER NON-CONFORM	ANCE	(NCR)	1			
	0750	Description of NC	Corrective Action Section			Sign &	Verifi	cation	Approval	Approval
DATE	STEP Description of NC Section A		Initial Chief Eng	Action Description Chief Eng		Section C		Chief Eng	QC Inspector	
: - -										
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ENGINEERING UNCONTROLLED COPY

DESIGN	N MB	DRAWN BY MB	DART AEROSPAC HAWKESBURY, ONTARIO, O	
CHECK	ED#	APPROVED #	DRAWING NO. D3436	REV. A SHEET 1 OF 4
 DATE	05.0)4.28	MAINTENANCE STEP	SCALE 1:4
Α	0	5.04.28	NEW ISSUE	

05.05-27



NOTES:

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
 2) WELD PER DART QSI 004
 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 7) ALL DIMENSIONS ARE IN INCHES

- 7) ALL DIMENSIONS ARE IN INCHES

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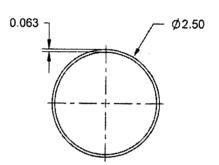
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
!									
Part No		PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Disposition	on:	_ QA: N/C Cl	osed:		Date: _	
NCR:		\	WORK ORE	ER NON-CONFORM	ANCE (NCR	1)			
DATE	OTED	Description of NC	of NC Corrective Action Se			Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		tion C	Chief Eng	QC Inspector
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DESIGN MB	DART AEROSPACE HAWKESBURY, ONTARIO, CA		
CHECKED	APPROVED #	DRAWING NO. D3436	REV. A SHEET 2 OF 4
DATE 05 (04.28	MAINTENANCE STEP	SCALE 1:2

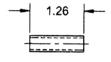
u/0 45/57

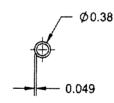




D3436-1 CLAMP

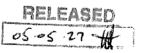
1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)





D3436-5 BUSHING

2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)



D3436-1/-5, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

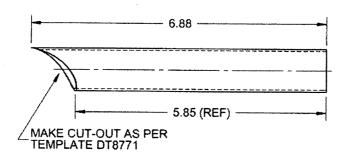
COPYRIGHT © 2005 BY DART AEROSPACE LTD.

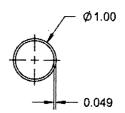
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DATE	STEP	PRO	CEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Cate	gory:	NCF	R: Yes I	No DQ	A :	Date: _	
	R	esolution:	Dispositio	on:	QA:	N/C Clo	sed:		Date: _	
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DATE	STEP	Description of NC Section A	Initial	Corrective Action Se Action Description	ection B	Sign &		cation ion C	Approval Chief Eng	Approval QC Inspector
		Section A	Chief Eng	Chief Eng		Date			Office Erig	Q moposion
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CHECKED	APPROVED	DRAWING NO. D3436	REV. A SHEET 3 OF 4					
DATE 05.0	4.28	MAINTENANCE STEP	SCALE 1:2					

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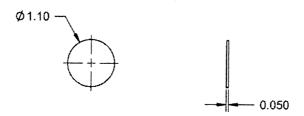




D3436-3 LEFT STEP

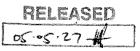
(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



D3436-7 CAP

2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)



D3436-3/ -7, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

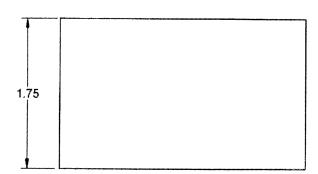
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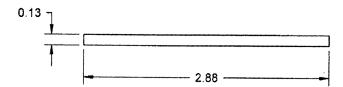
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DATE	STEP	PRO	CEDURE CHAI	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	R	esolution:	Disposition	1:	QA: N/C	Clos	ed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORI	MANCE (N	CR)				
DATE	STEP	Description of NC	Initial	Corrective Action S Action Descriptio	Section B	ın &	Verific		Approval	Approval
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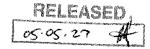


DESIGN MB	DRAWN BY MB	DART AEROSPACE HAWKESBURY, ONTARIO, C	
CHECKED	APPROVED #	DRAWING NO. D3436	REV. A SHEET 4 OF 4
DATE 05.0	04.28	MAINTENANCE STEP	SCALE 1:1



w/065157





D3436-9 PAD

NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK (REF, DART SPEC. M-NEO60-S, 125) 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES

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W/O:	•		V	ORK ORDER	CHANGES					:
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DATE	STEP	Description of NC		Corrective Acti		Ciam 9	Verific		Approval	Approval
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